

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010129**Date Inspected:** 28-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming, Gong Liang Zhu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 11 West Tower Lift 4 Turn Round Equipment Area AE & DE Corner

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15%, Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT and UT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WSTL4-2B/L-60A

WSTL4-2B/L-60A/B

WSTL4-2B/L-61A

WSTL4-2B/L-61A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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FCAW welding of weld joint 13 located on SD1-A440-2.

Welder is identified as 069043. ZPMC CWI is identified as Mr. Wang Chuan Qing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 2A/B (Repair) located on SSD1-SPSA3-56.

Welder is identified as 062782. ZPMC CWI is identified as Mr. Liu Zhong An.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-REPAIR.

SMAW welding of weld joint 8A/B (Repair) located on ED1-A6003-5.

Welder is identified as 052493. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-FCM-REPAIR-1.

SMAW welding of weld joint 9A located on ED1-A6003-8.

Welder is identified as 040269. ZPMC CWI is identified as Mr. Li Ming.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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